

Work Order ID 81120

81120

Page 1

March-08-12 8:53:39 AM

Item ID: D412-630-034

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli Access Step RH Folding

Stop ***NS2***

Start Date: 08/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/09 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN D412-630	Rev M
--------------	-------

100	DOCUMENT CONTROL	0.00
-----	------------------	------

100

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

JB 12/06/14

After MLJ 12-6-13
(4)

110	Small Fab	0.00
-----	-----------	------

110

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M119317

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M114596

4x

12/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.00

Quality Control

4

12/06/13

4
4

12/06/13
12/06/13 JB

8/2/2014

4
4

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-034								
	Location: <u>III</u>								
	PPP Rev: <u>A</u>								
160		0.00							
160	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

(4x) 12/6/14 (4)

12/6/18

MLJ 12/06/14

W/O:		WORK ORDER CHANGES					
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March-08-12 8:53:44 AM

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Work Order ID: 81120

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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 *AN310C8* Nut		Purchased	No			110	Each	38.0000	2	8			
										**		M/12/708	120769

Location	Loc Qty	Loc Code
ST344	38	
118378	2	
120308	6	
120644	10	
120769	20	

AN3C21A *AN3C21A* BOLT		Purchased	No			110	Each	72.0000	2	8			
										**			

Location	Loc Qty	Loc Code
ST352	72	
109148	2	
119798	50	
120781	20	

AN8C16 *AN8C16* Bolt		Purchased	No			110	Each	50.0000	2	8			
										**			

Location	Loc Qty	Loc Code
ST343	50	
106066	2	
120578	16	
120748	12	
120832	20	

M/12/593
12/6/0

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Parent Item Name: Heli Access Step RH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

D2012-107

Manufactured No

110

Each

21.0000

1

4

D2012-107

Clevis

**

82039

Location

Loc Qty

Loc Code

ST004

21

75057

21

D2803-042

Manufactured No

110

Each

3.0000

1

4

D2803-042

Bracket Assembly

**

82396

B83945

Location

Loc Qty

Loc Code

ST147

1

79182

1

ST149

2

79522

2

D2804-042

Manufactured No

110

Each

4.0000

1

4

D2804-042

Bracket Assembly

**

B82387

12/2/6

Location

Loc Qty

Loc Code

GA

2

79524

2

ST148

1

79185

1

ST150

1

76183

1

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D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

D2807-041

Manufactured No

110

Each

19.0000

2

8

**

D2807-041

Door prop

Location

Loc Qty

Loc Code

ST018

19

60540

2

68494

5

80165

12

D2813

Manufactured No

110

Each

45.0000

2

8

**

D2813

Washer

Location

Loc Qty

Loc Code

ST018

45

69386

1

79691

24

80848

20

D3395-1

Manufactured No

110

Each

13.0000

4

16

**

D3395-1

Bushing

Location

Loc Qty

Loc Code

ST041

13

71563

13

D3562-042

Manufactured No

110

Each

0.0000

1

4

**

D3562-042

Step Assembly, RH

March-08-12 8:53:44 AM

Shop Packet Print

Page 3

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D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

110

Each

999.0000

4

16

MS21043-3

Nut

**

M121258

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

350

120693

350

ST300

84

119901

84

ST301

493

118077

2

118614

441

118686

30

119758

20

MS24665-302

Purchased

No

110

Each

213.0000

2

MS24665-302

Cotter Pin

**

8

Location

Loc Qty

Loc Code

ST309

213

117460

13

120521

200

MS24693-C280

Purchased

No

110

Each

37.0000

2

MS24693-C280

Screw

**

8

Location

Loc Qty

Loc Code

ST289

25

120498

25

ST310

12

118612

12

March-08-12 8:53:44 AM

Shop Packet Print

Page 4

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D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3

Purchased

No

110

Each

256.0000

6

NAS1515H3

Washer

**

Location

Loc Qty

Loc Code

ST277

256

118078

6

118384

11

119438

4

120142

45

120518

90

120770

100

NAS1515H5L

Purchased

No

110

Each

82.0000

4

*NAS1515H5I *

WASHER

**

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

42

119902

42

NAS1515H8

Purchased

No

110

Each

67.0000

4

NAS1515H8

Washer

**

Location

Loc Qty

Loc Code

ST277

67

111275

4

111411

63

March-08-12 8:53:44 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D412-630-034

D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

AN44C7A

Purchased

No

130

Each

34.0000

0 4

**

AN44C7A

Eyebolt

Location

Loc Qty

Loc Code

ST362

34

111308

24

120872

10

111308

AN4C10A

Purchased

No

130

Each

58.0000

0 4

**

AN4C10A

Bolt

Location

Loc Qty

Loc Code

ST356

58

112243

2

114523

30

120820

16

120840

10

1X 114523
3X 120820

AN4C15A

Purchased

No

130

Each

239.0000

2 8

**

AN4C15A

Bolt

Location

Loc Qty

Loc Code

ST358

239

115835

2

118706

37

120360

200

118706

March-08-12 8:53:44 AM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D412-630-034

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Parent Item Name: Heli Access Step RH Folding

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C6A

Purchased

No

130

Each

358.0000

4

**

121656 JB

AN4C6A

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

354

116704

7

119749

47

120423

200

120521

100

AN5C15A

Purchased

No

130

Each

78.0000

8

**

JB

AN5C15A

Bolt

Location

Loc Qty

Loc Code

ST338

78

118191

3

119749

20

120422

30

120833

25

D2806-1

Manufactured

No

130

Each

27.0000

8

**

82033 JB 12/06/13

D2806-1

Bushing

Location

Loc Qty

Loc Code

ST018

27

78888

2

79527

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

D2806-3 Manufactured No

130 Each

16.0000

D2806-3
Bushing

2 8

**

82034 JB

Location

Loc Qty

Loc Code

ST018

16

79528

16

130

Each

7.0000

D2810-5 Manufactured No

D2810-5
Strut

1 4

**

282250 JB
1x 81072
3x 82256

Location

Loc Qty

Loc Code

ST265

7

52034

1

79690

6

130

Each

16.0000

D3396-1 Manufactured No

D3396-1
Spacer

2 8

**

82036 JB

Location

Loc Qty

Loc Code

ST041

16

78885

16

130

Each

1,257.000

MS21043-4 Purchased No

MS21043-4
Nut

4 16

**

121162 JB 12/06/13

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1217

119546

435

120308

782

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Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

130

Each

507.0000

12

**

MS21043-5

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

62

112314

62

ST301

425

116548

100

118159

100

119307

25

119537

200

NAS1515H4

Purchased

No

130

Each

173.0000

28

**

NAS1515H4

Location

Loc Qty

Loc Code

ST277

173

116169

3

117460

1

117735

3

118078

48

118612

9

120120

50

120498

9

120770

50

March-08-12 8:53:44 AM

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W/O:		WORK ORDER CHANGES					
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Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H5

Purchased

No

130

Each

242.0000

28

✓

S *NAS1515H5*
Washer

**

JB

12/06/13

Location

Loc Qty

Loc Code

FG

25

103286

5

103691

20

GA

100

120449

100

ST277

117

120299

17

120304

100

120449

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

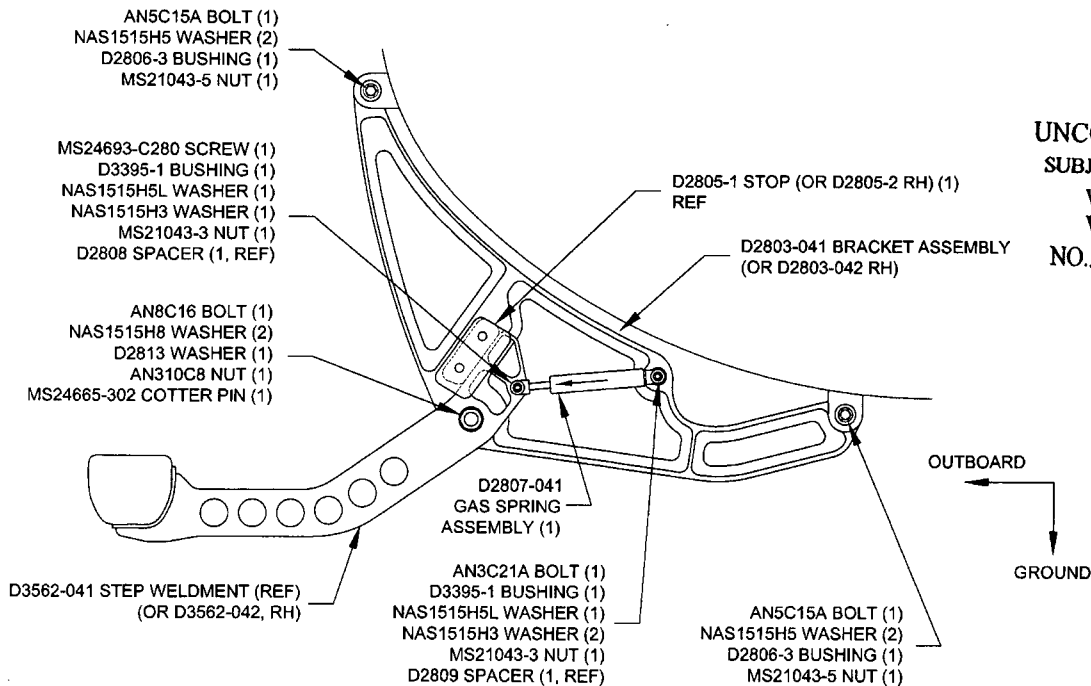
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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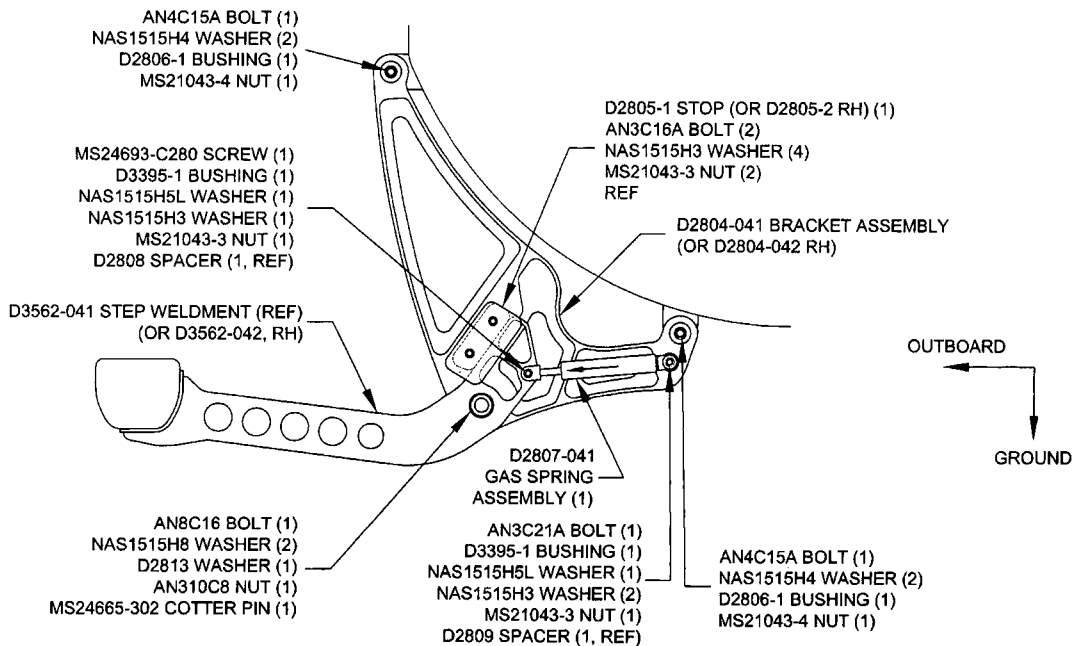
NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81120 MCJ
12/03/09

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: **M**
Date: 08.12.12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81120.

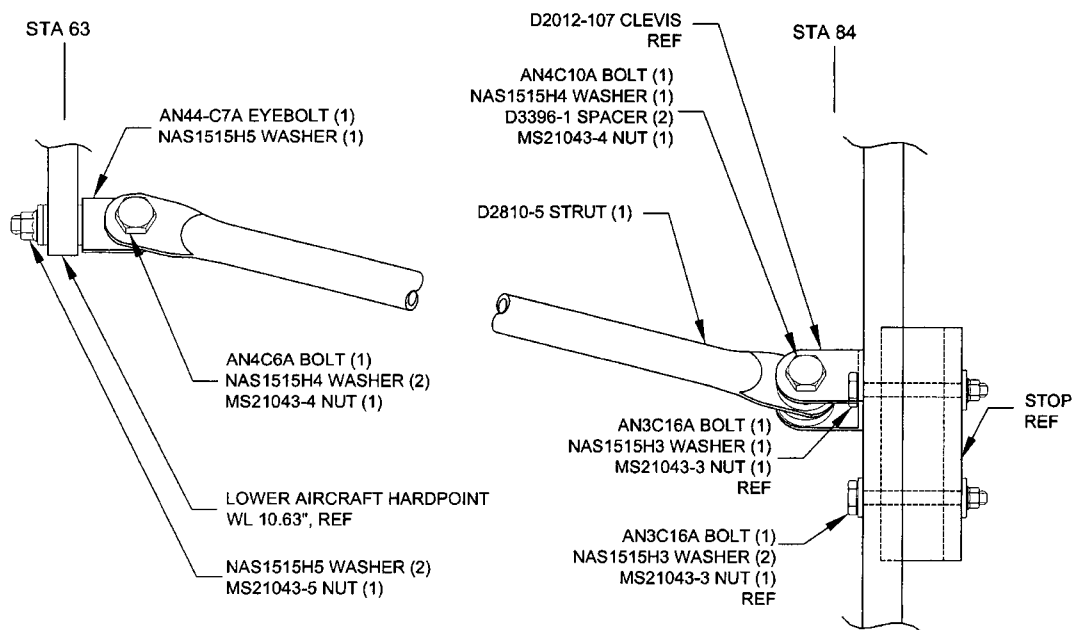


FIGURE 16 – Strut Detail for D412-630-033/-034 *Heli-Access-Step™* Installation
(NOT TO SCALE)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

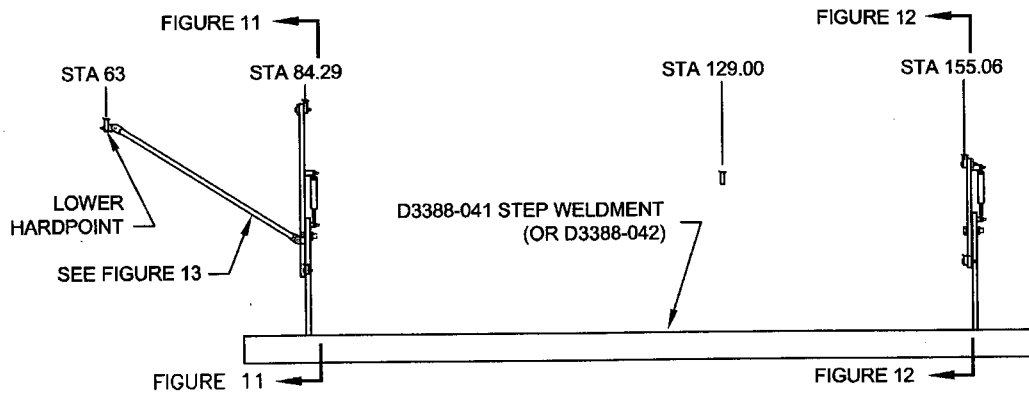
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

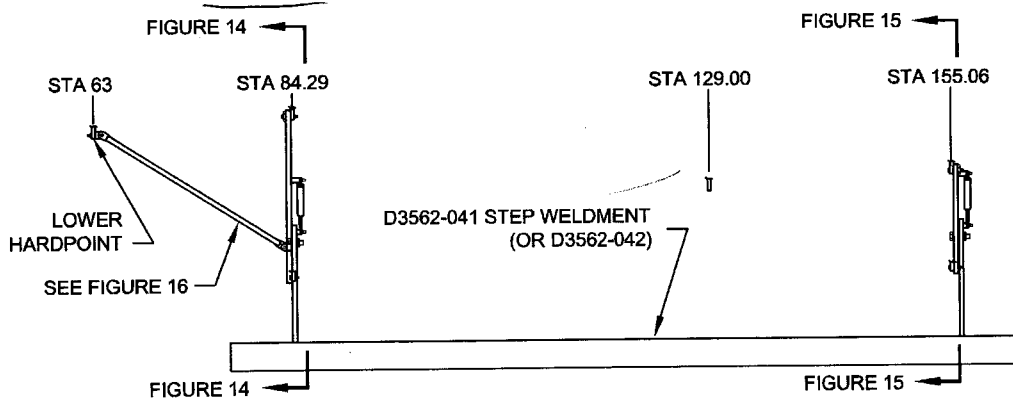
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

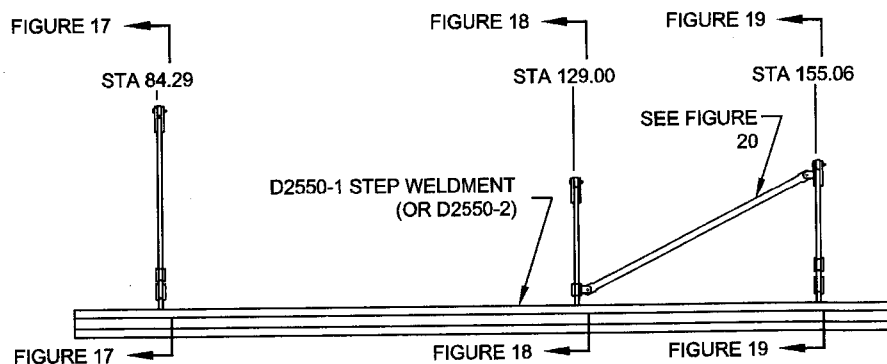


FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: **M**
 Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)